

1st split

Work Order ID 53212-1

October 26, 2009 2:18:24 PM

Page 1

Item ID: D4013-041
Revision ID: A-PRELIM 09.10.28
Item Name: Wearplate Assembly

PRELIMINARY ISSUE

Start Date: 10/26/09 Start Qty: 4.00
Required Date: 10/28/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

A-PRELIM

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D4013-1

Dwg Rev: PRE
Prog Rev: LM

2-Deburr if necessary

HB 9-10-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 9-10-27

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53212

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Page 2

Item ID: D4013-041
Revision ID: A-PRELIM
Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 10/26/09 Start Qty: 4.00
Required Date: 10/28/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 Serial 10/27

SPC 09/10/28

27 Serial 10/28

(26)

f

(6)

(46)

d

W/O:		WORK ORDER CHANGES						
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Work Order ID 53212

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Item ID: D4013-041

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Start Date: 10/26/09 Start Qty: 4.00

Required Date: 10/28/09 Req'd Qty: 4.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Memo

0.00

Weld cup, stud and apply hardfacing as per dwg

A/R S.S. ROD BATCH: M108/60

A/R HARDCOAT 2059B BATCH: M112963

EL 9-10-28 *(X3)*

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 509/10/29 *109/10.21*

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

109/10/29

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NOTE: Date & initial all entries

Work Order ID 53212

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Item ID: D4013-041
Revision ID: A-PRELIM
Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 10/26/09 Start Qty: 4.00
Required Date: 10/28/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

NOT PAINTED

USE FOR TESTING
SCRAP REMAINING
PARTS. 10/27/09

R00324401

10/26/09

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

W/O:		WORK ORDER CHANGES						
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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

A. 09.10.30 Prototype

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

October 26, 2009 2:18:23 PM

Page 1

Work Order ID: 53212

Parent Item: D4013-041

Parent Item Name: Wearplate Assembly



Comments:







Start Date: 10/26/09

Required Date: 10/28/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	219.8531	4.0842	6.1263		
304/316 Sheet .063												LB 9-10-27

D4013-3 		Manufactured	No			150	Each	0.0000	4.0000			
Stud												
D4013-5 		Manufactured	No			150	Each	0.0000	4.0000			
Cup												
D3009-3RevB 		Manufactured	No			150	Each	609.0000	4.0000			
Cup												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	219.8530737	
106860	16.018	
111924	25.1689737	
112442	43.1663	
112567	7.4998	
112885	128	

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	609	
42376	158	
42377	451	

B 53183

x 8 9

B 53184

x 8 12

EL 7-10-28

EL 7-10-28

EL 7-10-28

4218

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53212
Description: WEAR PLATE ASS'y		Part Number: D4013-041
Inspection Dwg: D4013-1 Rev: PRE Lim		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .066 - .001	.263	X			
Ø .875	+ .010 - .001	.877	X			
Ø 1.88	+ .012 - .001	1.880	X			
1.500	± .010	1.503	X			
2.125	± .010	2.124	X			
2.75	± .030	2.74	X			
.625	± .010	.625	X			
2.125	± .010	2.123	X			
3.625	± .010	3.626	X			
7.063	± .010	7.065	X			
7.458	± .010	7.459	X			
11.271	± .010	11.274	X			
14.896	± .010	14.896	X			
18.646	± .010	18.646	X			
22.396	± .010	22.396	X			
24.106	± .010	24.106	X			
25.231	± .010	25.231	X			
1.50	± .020	1.503				
.663	± .010	.659	X			

Measured by: MB	Audited by: S	Prototype Approval:	N/A
Date: 9-10-07	Date: 08/10/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Receiving Report

Date: 9/9/02

Batch No: M112567

Supplier: MAWA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ 8/9/02 N/A ☐
 Work Order 09109102 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200x0400	40	0	0	40	
M6061	30181x0400	40	0	0	40	
M6061	TGB1-200x0400	40	0	0	40	

M6061 TGB-620

Initials of receiver (if shipment OK) Level 12

Production/Admin: 09/09/02
 Date: 09/09/02
 Received/Costing: RCR 10312
 Initial: CY

Location _____

M 3045126A

69 0 0 69

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09

PO Print Date 9/01/09

Page Number 4 of 4

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

16	✓ M304S16GA	304/316 Sheet .063	9/04/09	✓ 96 92.00	Yours ppd	\$5.0000	\$460.00
			Yes	sf			

Special Inst: AS ABOVE

17	✓ M304S20GA	304/316 .040 Sheet	9/04/09	✓ 192.00		\$3.9062	\$749.99
			Yes	sf			

Special Inst: AS ABOVE

PO Total: \$5,356.49

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/01/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

MILL TEST REPORT

TA CHEN INTERNATIONAL CORPORATION

www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: TICL2121 Customer#: MAGDOR PO#: P006327 SO#: PE6925

Item#: 16GA48963042B Bundle#: KA80261180E10H5 Heat#: A2800233



INSPECTION CERTIFICATE

TICL2121

Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

CERTIFICATE NO. T08-692B

MATERIAL AISI304 NO.2B FINISH

SPECIFICATION ASTM A240-04/A480-04, ASME SA240/A480
ASTM A666, AMS 5513/5511

L/C No.

CUSTOMER

CONTRACT NO.

DATE OF ISSUE

Ta Chen International, Inc.

L22628

20080401

Product

Melting furnace

Inspectors stamp

Mark of the Manufacturer

SHEET

E+VOD



Shanxi Taiyuan Stainless Steel Co.,Ltd

NO.	Heat No.	Coil No.	Hatch No.	Quantity	Dimensions (inch)	Weight(Pound)
43	C3706216	KA71272980F00H3	78253308	1	16GA x 48" x 120	4535
44	C3706216	KA71272980F00H2	78253309	1	16GA x 48" x 120	4546
45	A2800233	KA80261180E10H5	78255632	1	16GA x 48" x 96	4270
46	A2800233	KA80261180E20H1	78255634	1	16GA x 48" x 96	4259
47	A2800233	KA80261180E20H2	78255636	1	16GA x 48" x 96	3874
48	A2800233	KA80261180E20H3	78255638	1	16GA x 48" x 96	4348
49	A2800233	KA80261180E20H4	78255640	1	16GA x 48" x 96	3896

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	N	Mo	Ti
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	

Mechanical Properties (Test temperature :20°C)

Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation		Corrosion Tests	Hardness		
				A5 (%)	A50 (%)		HRB	HV	HRC
78253308-T	660	305			54		91.5-90.5		
78253309-T	660	305			54		91.5-90.5		
78255632-T	645	299			51		87.5-88.0		
78255634-T	645	299			51		87.5-88.0		
78255636-T	645	299			51		87.5-88.0		
78255638-T	645	299			51		87.5-88.0		
78255640-T	645	299			51		87.5-88.0		

SPECTROMETER SORTING TEST: OK

EN 10204-3.1B

Mercury Free

Place: Taiyuan

Work Inspector: 李忠新



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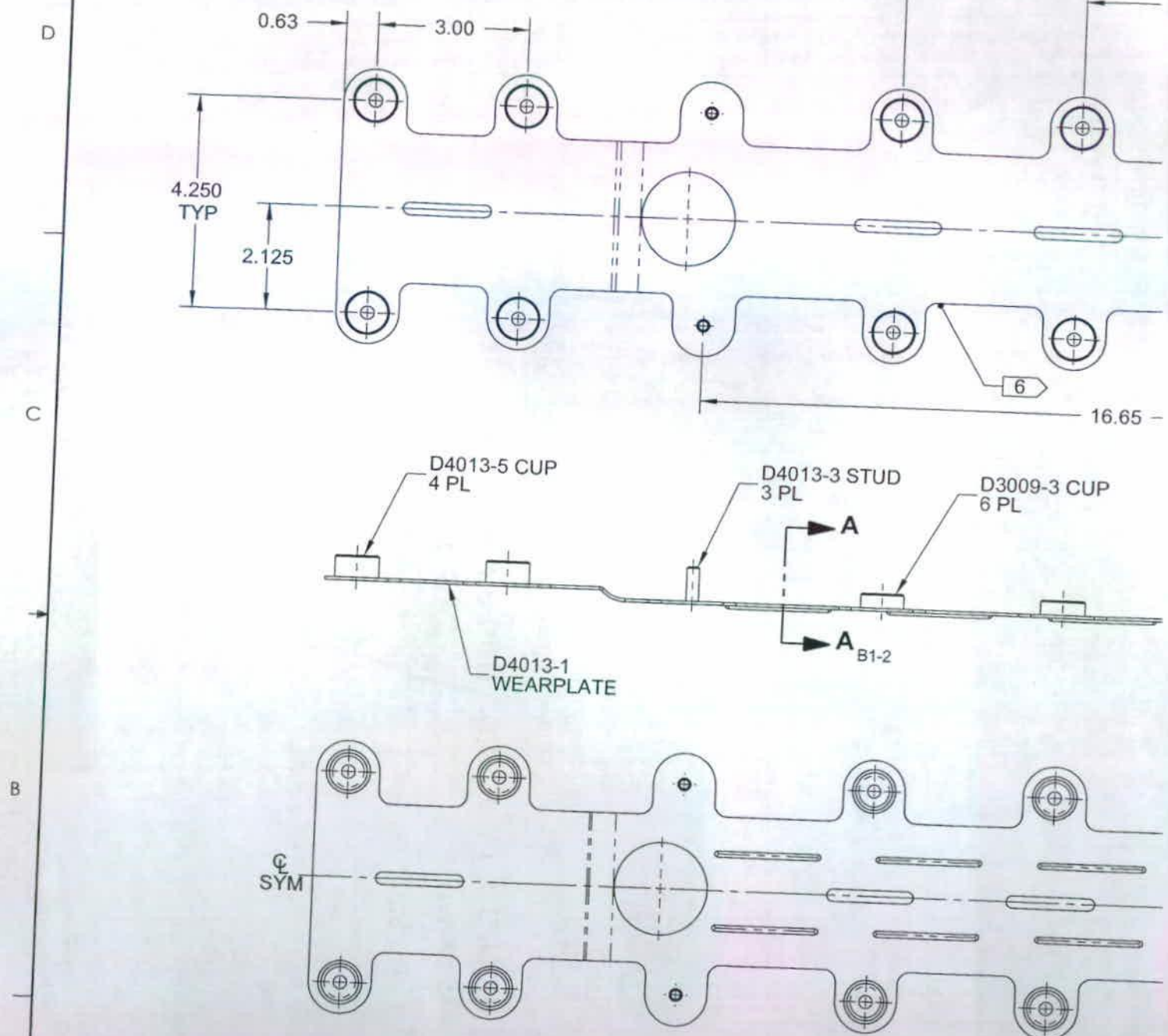
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries



D4013-041 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: SEE SHEETS 3 AND 4
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.72 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 10 PL

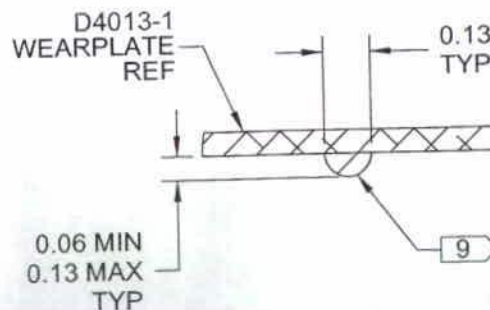
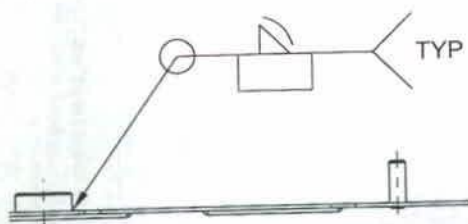
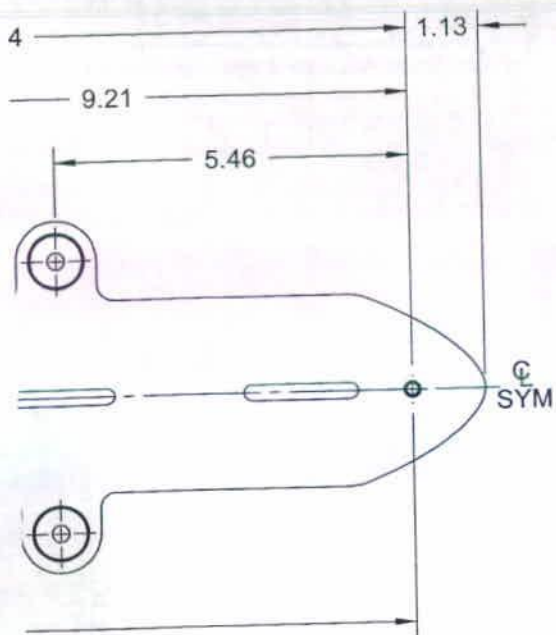
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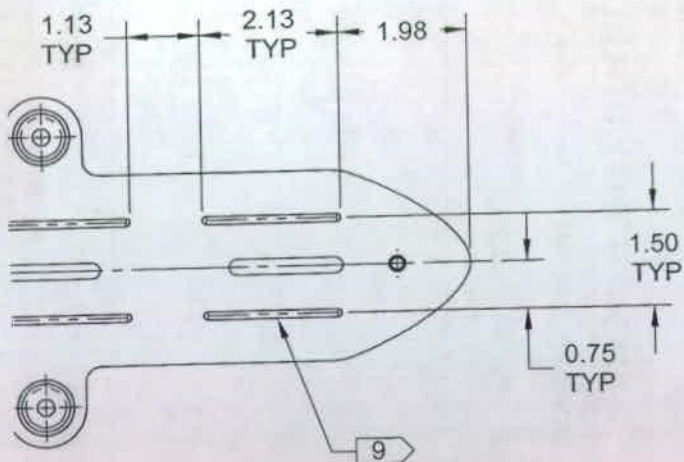
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SECTION A-A B6-2
SCALE 6X



PRELIMINARY ISSUE

2004.10.26
FOR ECN #09-0450

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	LS	DRAWING NO.	RE
MFG. APPR.		D4013	SHEET 2
APPROVED		TITLE	S
DE APPR.		WEARPLATE ASSEMBLY	
DATE	09.10.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

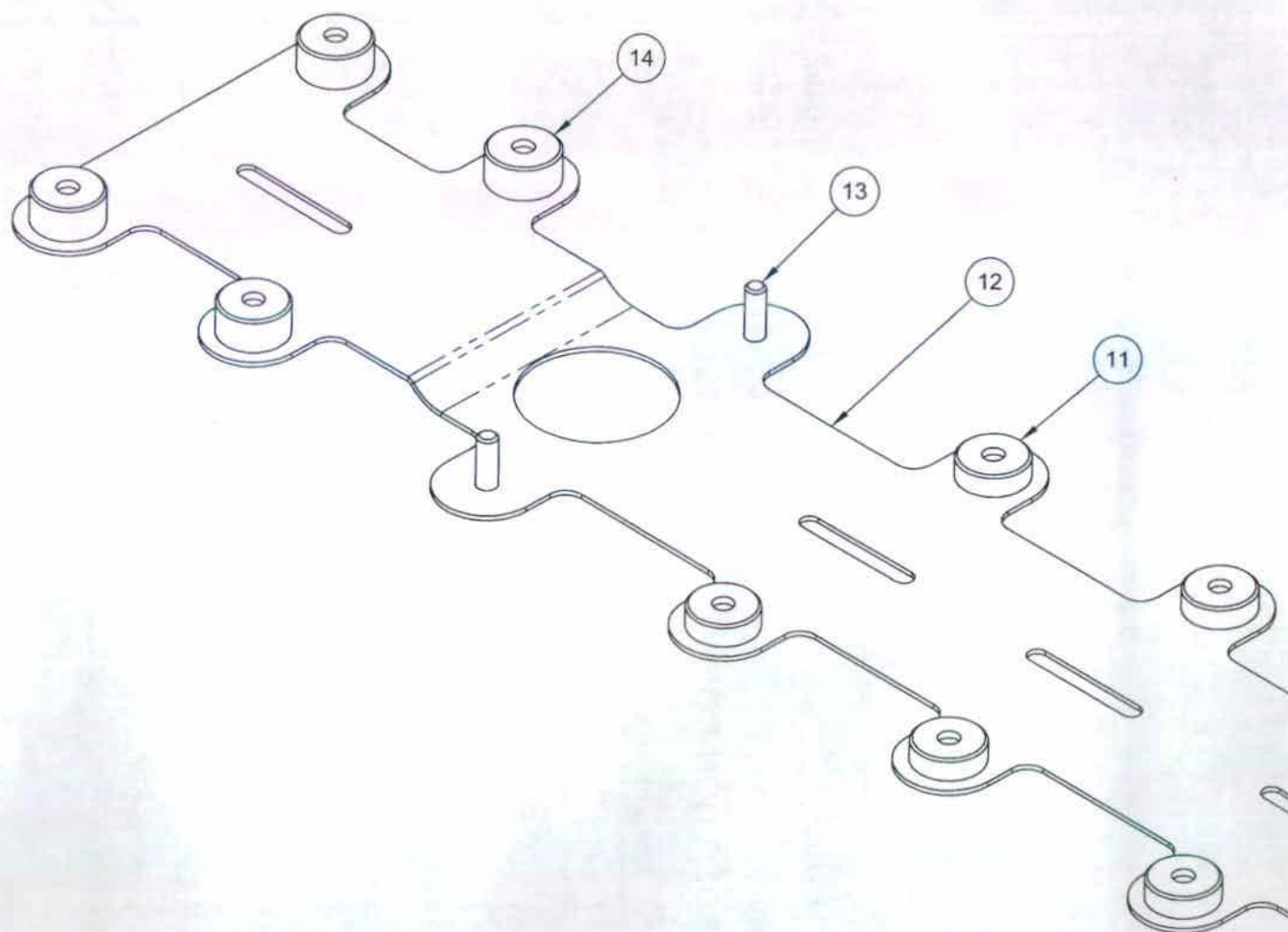
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1 D4013-041 WEARPLATE ASSEMBLY

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

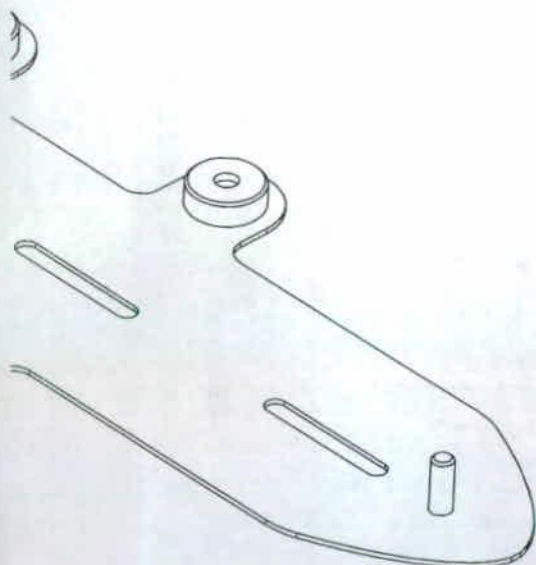
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4031-041	WEARPLATE ASSEMBLY
11	6	D3009-3	CUP
12	1	D4013-1	WEARPLATE
13	3	D4013-3	STUD
14	4	D4013-5	CUP
21	A/R	2059B	HARDCOAT



PRELIMINARY ISSUE

09.10.22
PER GCN #04-6958

A	NEW ISSUE		MB	09.10.22
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4013 TITLE WEARPLATE ASSEMBLY		REV. A	
DRAWN			SHEET 1 OF 4	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.				
DATE	09.10.22		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19.34

0.063
REF

WEARPLATE 4013-1F)

Ø0.875
TYP

1.50
TYP

0.75
TYP

R0.13

Ø
SYM

R0.250
TYP

R1.00

14.896

18.646

22.396

24.106

25.231

FLAT PATTERN

PRELIMINARY ISSUE
ASS RAB 07.10.26

DESIGN	ASS GMB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS RAB		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	ASS	D4013	SHEET 3 OF 4
APPROVED	ASS MP	TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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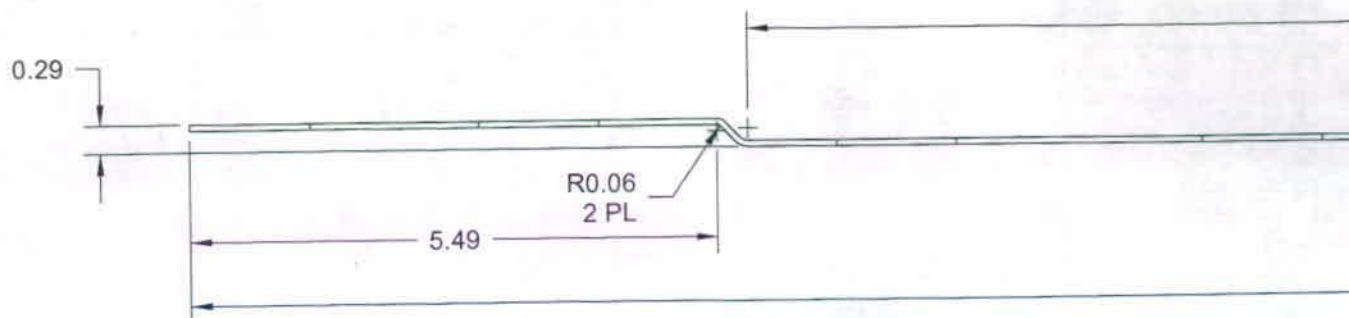
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

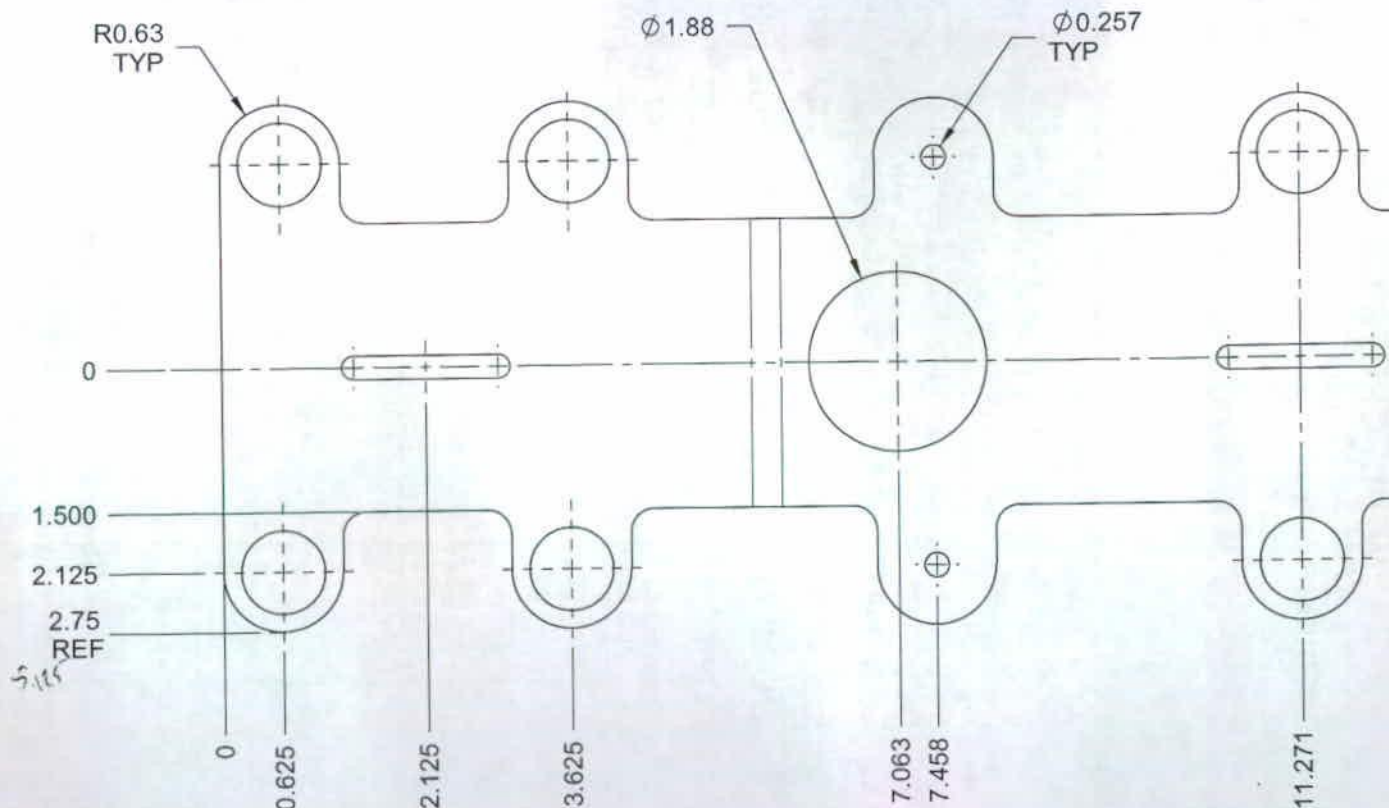
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4013-1
(MAKE Ff



D4013-1F WEARP

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.42 lbs

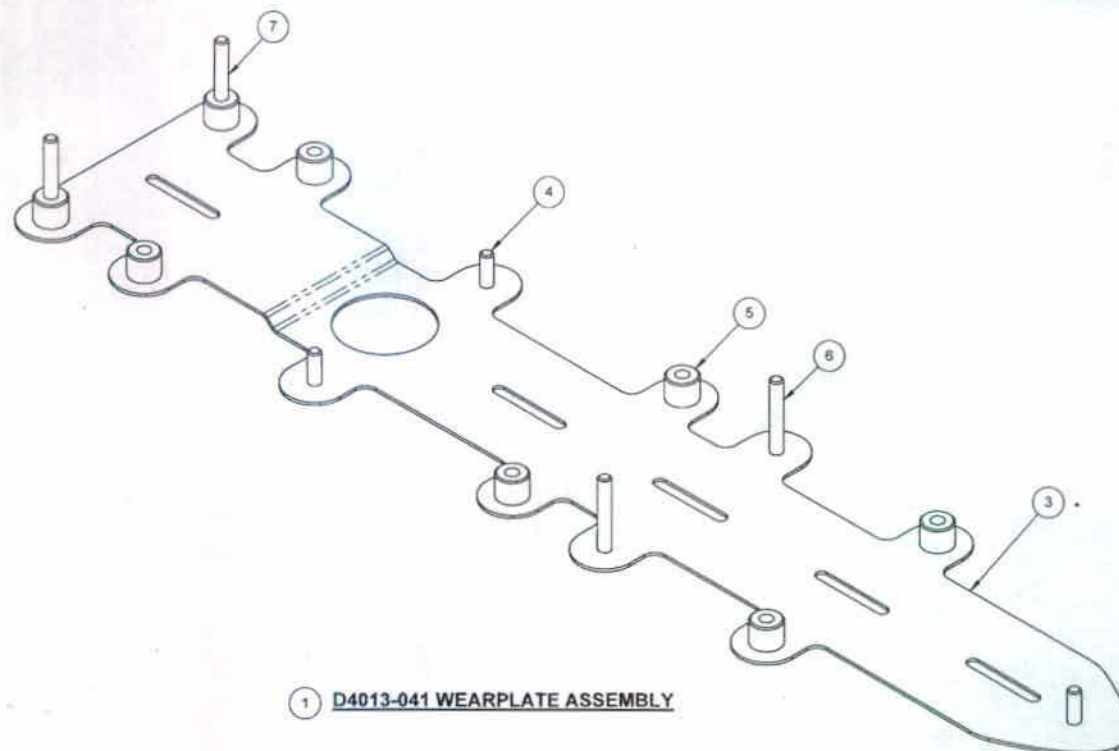
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



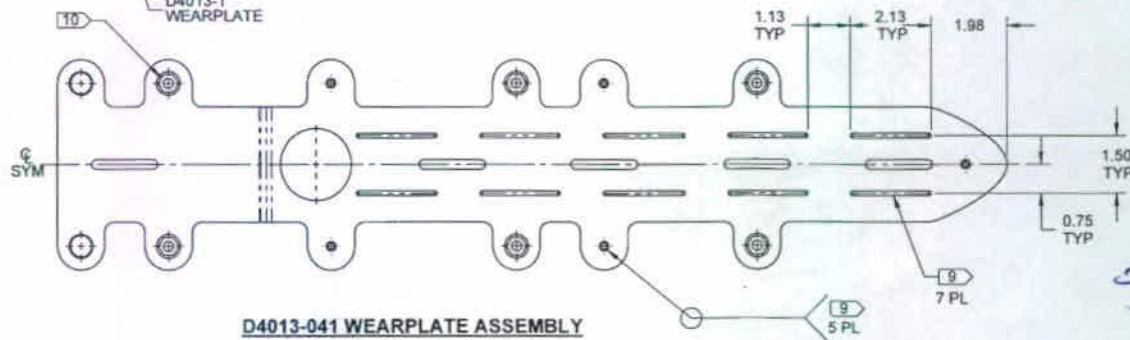
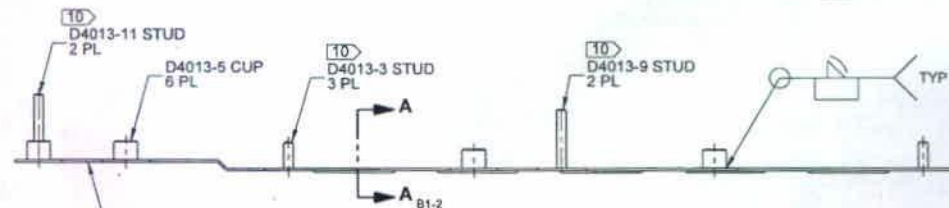
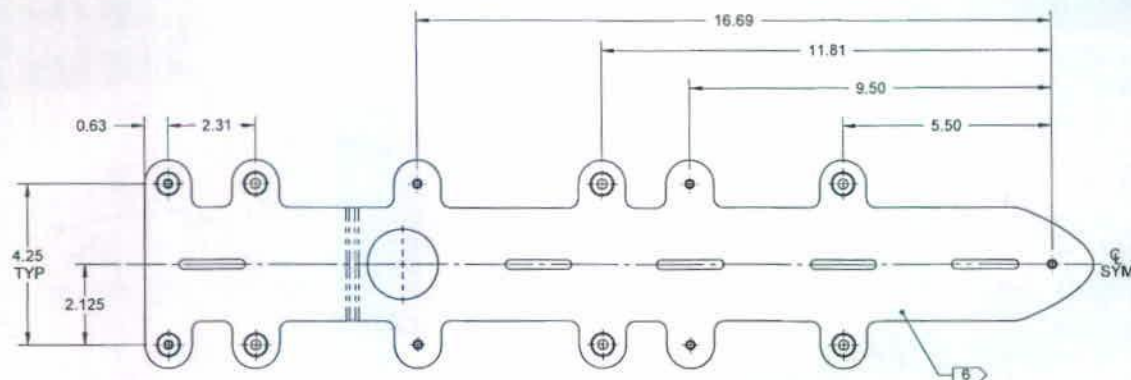
1 D4013-041 WEARPLATE ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

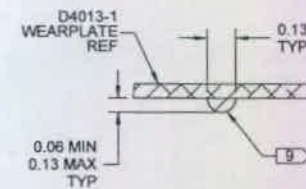
53212

RELEASED
2009-11-24
MP

C	SIMPLY DESIGN FOR MANUFACTURING PURPOSES. REDESIGNED ITEM 5. ELIMINATED D4013-7 CUP (NO LONGER USED). CHANGED FINISH FROM GREY TO BLACK SANDTEX	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	AS		
MFG. APPR.	18		
APPROVED	10		
DE APPR.	11		
DATE	09.11.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4013 TITLE WEARPLATE ASSEMBLY REV. C SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



D4013-041 WEARPLATE ASSEMBLY



SECTION A-A B6-2
SCALE 6X

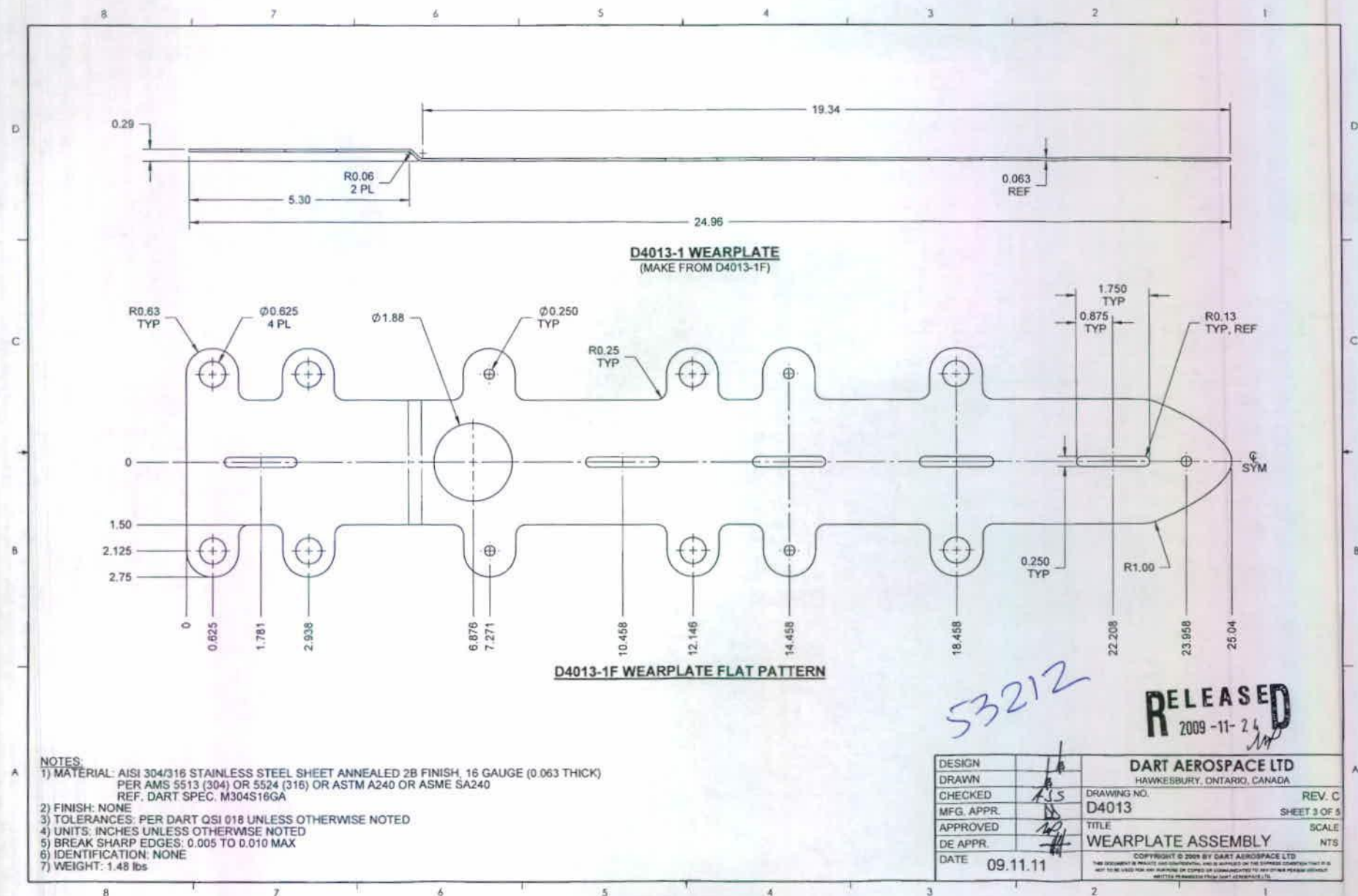
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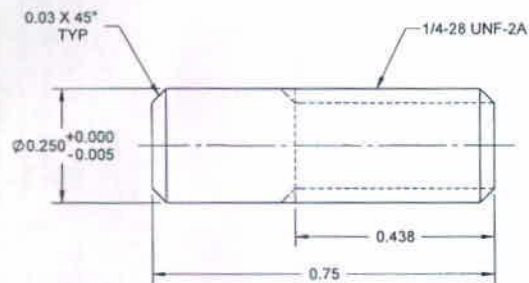
- 1) MATERIAL: SEE SHEETS 3 AND 4
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.89 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 10 PL
- 10) MASK THREADS (7 PL) AND HEXAGONAL OPENINGS (6 PL) PRIOR TO PAINTING

DESIGN	LA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LA	DRAWING NO. D4013	REV. C
CHECKED	AS	SHEET 2 OF 5	
MFG. APPR.	AS	TITLE WEARPLATE ASSEMBLY	SCALE NTS
APPROVED	AS	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DE APPR.	AS	THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION OF COMPARISON TO THE CANADIAN PATENT ACT OR TO THE UNITED STATES PATENT ACT	
DATE	09.11.11		

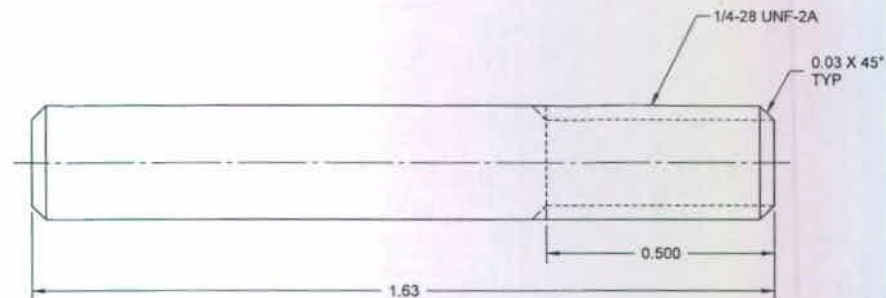
RELEASED
2009-11-24

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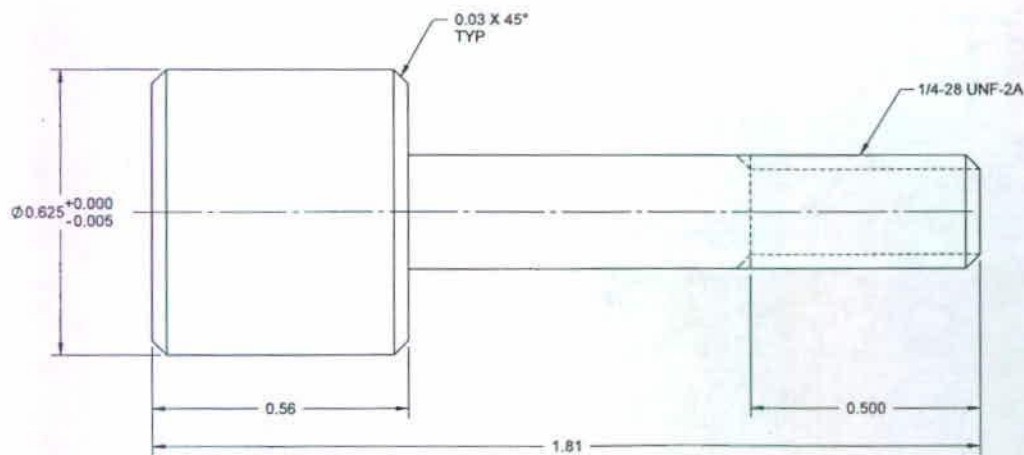




D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

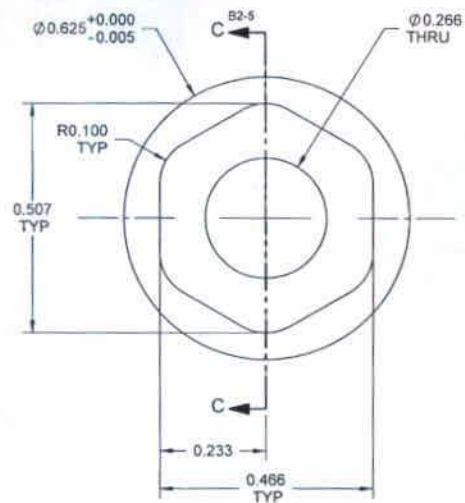
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

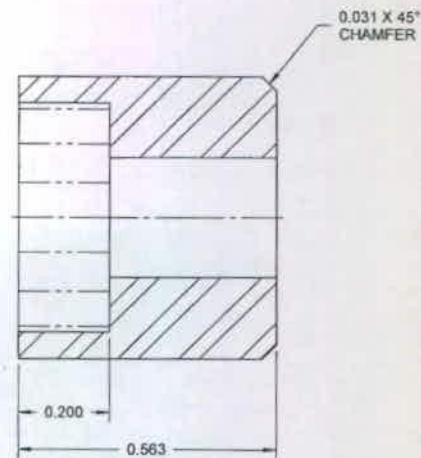
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2009-11-24

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>	DRAWING NO.	REV. C
CHECKED	<i>JS</i>	D4013	SHEET 4 OF 5
MFG. APPR.	<i>JS</i>	TITLE	SCALE
APPROVED	<i>JS</i>	WEARPLATE ASSEMBLY	NTS
DE APPR.	<i>JS</i>	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D4013-5 CUP



SECTION C-C D6-5

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	1	D4013	SHEET 5 OF 5
APPROVED	1	TITLE	SCALE
DE APPR.	1	WEARPLATE ASSEMBLY	NTS
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2009-11-24
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